

obtaining a hardened metal cylindrical blank having end face surfaces, a lateral surface defining an outer diameter, and a centered circular bore, said bore having an inner surface defining an inner diameter;

hard turning the inner surface of the bore having a specified inner diameter, thereby forming an inner bearing surface;

(P) Grind
hard turning the lateral surface of the blank to a specified outer diameter, thereby forming an outer bearing surface concentric with said inner bearing surface, and thereby producing a metal cylindrical bearing roller.

REMARKS

Claims 1-14 are pending in this application. Claims 1-14 have been rejected. Claim 1 is hereby amended.

Responsive to the rejection of claims 1-14 under 35 U.S.C. §103(a), as unpatentable over Applicants' Admitted Prior Art (AAPA) in view of US Patent 4,593,444 to Kavthekar, Applicants have amended base Claim 1, and submit that claims 1-14 are now in condition for allowance.

More particularly, Applicants have rewritten Claim 1, changing the transitional phrase from "comprising" to "consisting of." The Kavthekar reference discloses additional steps that are not included in the Applicant's invention. As noted by the Examiner in the office action, "Kavthekar discloses additional grinding after the hard turning..". *Emphasis Added.* In contrast, the Applicant's specification discloses, "whereas the prior art process entails three separate grinding operations....., the process of the present invention achieves the final form of the bearing, having a specified outer diameter (O.D) with a radial crown, in a single

hard turning of the blank's lateral surface." *Emphasis Added. Page 6, Lines 13-17.* The Applicant's invention discloses a manufacturing method for forming steel roller bearings in a minimal amount of machining steps. The amendment of Claim 1, changing the transitional phrase from "comprising" to "consisting of" is supported by the disclosure, as illustrated above, and further clarifies the difference between the Applicants' invention and the prior art, by precluding the addition of further manufacturing steps. The transitional phrase "consisting of" excludes any element, step, or ingredient not specified in the claim. *In re Gray*, 53 F.2d 520, 11 USPQ 255 (CCPA 1931); *Ex parte Davis*, 80 USPQ 448, 450 (Bd. App. 1948).

Additionally, Claim 1 was further amended to add the final step, "thereby producing a metal cylindrical bearing roller." This additional step is supported by the Applicants' disclosure, and serves to further differentiate the Applicants' invention, "a process to produce roller bearings", from the cited prior art invention, "a machine for manufacturing universal joints."

Accordingly, Applicants submit that claim 1, and claims 2-14 depending therefrom, are now in condition for allowance and respectfully request same.

In the event Applicant has overlooked the need for an extension of time, an additional extension of time, payment of fee, or additional payment of fee, Applicant hereby conditionally petition therefore and authorize that any changes be made to Deposit Account No.50-0831, DELPHI TECHNOLOGIES, INC.

Should you have any questions regarding the enclosed, please do not hesitate to contact me.

Respectfully submitted,

Date: 6-3-02



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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant:	Bauman et al.)	
)	
Serial No.:	09/576,731)	Examiner: E. Compton
)	
Filed:	May 23, 2000)	Art Unit: 3726
)	
For:	PROCESS FOR FORMING STEEL ROLLER BEARINGS)	
)	
)	

**MARKED-UP COPY OF AMENDMENTS TO THE SPECIFICATION AND
CLAIMS**

Hon. Assistant Commissioner for Patents
Box: AF
Washington, D.C. 20231

Dear Sir:

In compliance with 37 CFR §1.121, Applicant hereby submits the following marked-up copy of the revisions made to the Claims by the Amendment submitted in response to the Final Office Action mailed April 4, 2002.

IN THE CLAIMS

1. (*Twice Amended*) A process for forming a metal cylindrical bearing roller, said [comprising] consisting of the steps of:

obtaining a hardened metal cylindrical blank having end face surfaces, a lateral surface defining an outer diameter, and a centered circular bore, said bore having an inner surface defining an inner diameter;

hard turning the inner surface of the bore having a specified inner diameter, thereby forming an inner bearing surface; [and]

hard turning the lateral surface of the blank to a specified outer diameter, thereby forming an outer bearing surface concentric with said inner bearing surface, and
thereby forming a metal cylindrical bearing roller.

Should you have any questions regarding the enclosed, please do not hesitate to contact me.

Respectfully submitted,

Dated: 6-3-02



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